

Work Order ID 110120

\*110120\*

Page 1

December-17-13 9:15:32 AM

Item ID: D4035-043 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: Stop \*NS2\*  
Item Name: Lid Rib Assembly, Aft (350 Basket)  
Start Date: 12/17/13 Start Qty: 8.00 \*8\* 4x  
Required Date: 12/17/13 Req'd Qty: 8.00 \*8\*  
Reference: Cust Item ID:  
Customer:

Approvals: Process Plan: MLJ Date: 13-12-19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D4035	A								
100	Weld per dwg A/R S.S. rod Batch: <u>4163803</u>	0.00							
*100*									
Large Fab	Memo	0.00							
Large Fab	1- Cut D4035-3 as per dwg D4035 2- Drill holes using DT9563 and chamfer holes as per dwg D4035 3- remove identification marks and deburr 4- Weld bushing in rib and grind weld flush as per dwg D4035								
110	QC10- Inspect visual per QSI004- ground welds	0.00							
*110*									
QC	Memo	0.00							
Quality Control									

4x 2x DAS 43 14-01-09  
CPC 14-01-10



**Work Order ID 110120**

December-17-13 9:15:32 AM

**\*110120\***

Page 2

Item ID: D4035-043

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Lid Rib Assembly, Aft (350 Basket)

Start Date: 12/17/13 Start Qty: 8.00

~~\*8\*~~

4

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 8.00

~~\*8\*~~

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				<u>4</u>	<u>*</u>		
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>WA004</u>  Memo	0.00  0.00				<u>4</u>	<u>*</u>		
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00						<u>14-01-13</u>	<u>14-01-13</u>

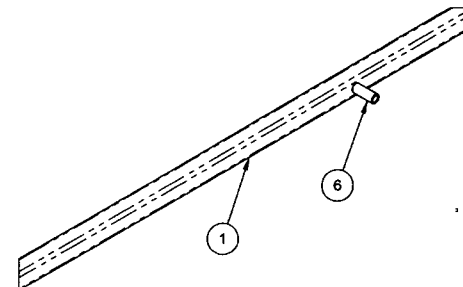
December-17-13 9:15:32 AM

**Required Qty: 8.00**

**Comments:** IPP revA: new issue DD 09.11.25 verified by:EC IPP Rev:B as per dwg revA 10.03.15  
verified by:EC IPP Rev:C 13.06.24 AS PER DWG REV.pb2 DD VRF:JFS

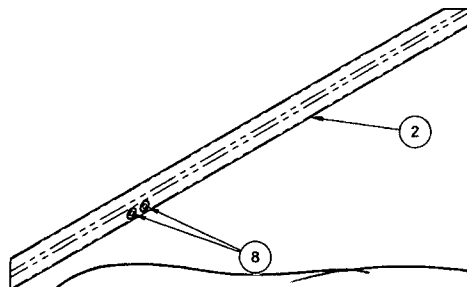
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4021-9 Bushing		Manufactured	No			100	Each	128.0000	2	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		128							
				102482		4							
				106513		25							
				107634		97							
				99143		2							
M304TS0.750W.049 304 SQ Tube .75x.75x.049W		Purchased	No			100	f	928.4540	1.75	15			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA004		928.4540331							
				M126039		89.9999331							
				M126364		211.2885							
				M126900		67.1656							
				M127493		560							

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING

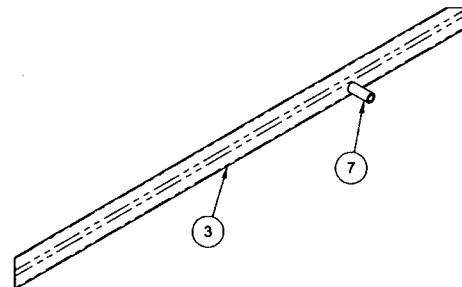


**D4035-041 BASKET LID RIB ASSY, FWD**

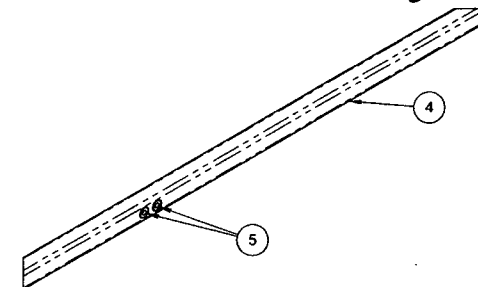
110120  
MCS  
13-12-19



**D4035-043 BASKET LID RIB ASSY, AFT**



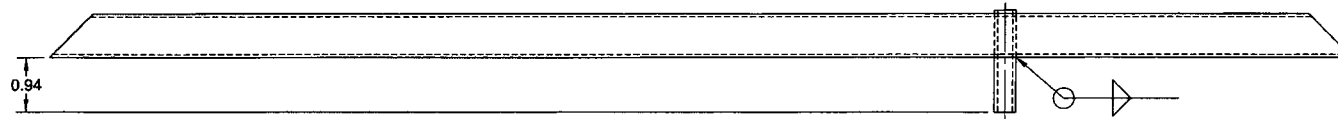
**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12  
MCS

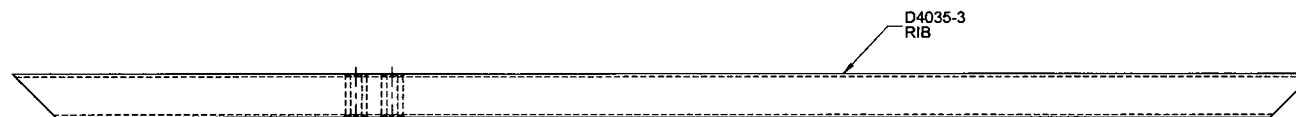
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH	DRAWING NO.	REV. A
CHECKED		D4035	SHEET 1 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET LID RIB ASSY	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.03.04		



D4035-1  
RIB

D2327-3  
SPACER BUSHING

**D4035-041 BASKET LID RIB ASSY, FWD**



D4035-3  
RIB

D4021-9  
BUSHING  
2 PL

TYP

**D4035-043 BASKET LID RIB ASSY, AFT**

**RELEASED**  
2010-03-12  
WDO

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.83 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

D4035-5  
RIB

D2953-175  
SPACER

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

D4035-11  
BUSHING  
2 PL

TYP

**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4035</b>	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>BASKET LID RIB ASSY</b>	NTS
DATE	10.03.04	<small>           COPYRIGHT © 2010 BY DART AEROSPACE LTD            THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS            NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT            WRITTEN PERMISSION FROM DART AEROSPACE LTD.         </small>	

